



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-698-041
Job Sheet 179700



Part No: D412-698-041

Job Qty: 1 ea

Part Name: Hinge Panel Automatic Door Opener LH OEM Aluminum Door



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP REV:A 11.08.18 new issue DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Stores/Pkg-2		6	JUL 09 2018
110	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging1-4		6	JUL 19 2018
120	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC4		28	
130	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		28	
135	DC	1 pcs	7/13/18	7/13/18	0.00	0.00	DC		21	
140	QC21-FG	1 Ea	7/13/18	7/13/18	0.00	0.00	QC21		21	JUL 20 2018

Part Op
Descriptions: 135 - Photocopy bluefile and create labels per PPP D412-698-041 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-21	Door Prop	1 Ea (1 ea)	90-Start up Operation	3073169
D3622-1	Ball Stud	1 Ea (1 ea)	90-Start up Operation	3081607
D4330-041	Airframe Bracket Assembly, LH	1 Ea (1 ea)	90-Start up Operation	3083887
D4330-3	Door Bracket	1 Ea (1 ea)	90-Start up Operation	3083567
MS21042L5	Nut	1 Ea (1 ea)	90-Start up Operation	3058178
NAS1149D0563J	Washer	1 Ea (1 ea)	90-Start up Operation	3068662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3552-21	1	7	0
	D3622-1	1	40	0
	D4330-041	1	0	0
	D4330-3	1	0	0
	MS21042L5	1	558	0
	NAS1149D0563J	1	1,919	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ _____	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																																																						
Date : _____ Step _____	MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																							
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S090184 Part: D412-698-041 Job No: 179700 Serial No/Batch: S090184 Revision: G Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/09/18																																																								
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> <th colspan="2"></th> </tr> <tr> <td style="width: 25%;">Environment</td> <td style="width: 25%;">☐</td> <td style="width: 25%;">No Re-verification</td> <td style="width: 25%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> </table>					Root Cause				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
Root Cause																																																								
Environment	☐	No Re-verification	☐																																																					
Design	☐	Operator	☐																																																					
Doc/Data	☐	Offset/Setup	☐																																																					
Equip/Tooling	☐	Supplier	☐																																																					
Handling/Pre	☐	Training	☐																																																					
Material	☐	Use for Testing	☐																																																					
Internal Transport	☐	Poor Information	☐																																																					
Tribal Knowledge	☐	Rushing	☐																																																					
LOA	☐	Product Improvement	☐																																																					
Substation	☐	Process Improvement	☐																																																					
Past Expiry Date	☐	Manufacturing Process	☐																																																					
Misidentified	☐	Past Due	☐																																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 33%;"> Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter </td> <td style="width: 33%;"> BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes </td> <td style="width: 33%;"> Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center </td> </tr> </table>					Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center																																																	
Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center																																																						
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 33%;"> Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence </td> </tr> </table>					Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence																																																			
Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence																																																								
OTHER : _____																																																								

REFERENCE ONLY

9.0 PARTS LIST – HINGE PANEL AUTOMATIC DOOR OPENER KITS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D412-698-041	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (FOR OEM ALUMINUM DOORS)
	X			D412-698-042	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (FOR OEM ALUMINUM DOORS)
		X		D412-698-043	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (FOR OEM COMPOSITE AND DART SPACEDOORS™ DOORS)
			X	D412-698-044	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (FOR OEM COMPOSITE AND DART SPACEDOORS™ DOORS)
1	1	1	1	D3552-21	GAS SPING
1	1	1	1	D3622-1	BALL STUD
1		1		D4330-041	AIRFRAME BRACKET ASSEMBLY, LH
	1		1	D4330-042	AIRFRAME BRACKET ASSEMBLY, RH
1	1	1	1	D4330-3	DOOR BRACKET
		3	3	80-005-2-8	INSERT
1	1	1	1	MS21042L5	NUT
		3	3	MS27039-1-05	SCREW
		3	3	NAS1149D0332J	WASHER
1	1	1	1	NAS1149D0563J	WASHER

REFERENCE ONLY

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G

Date: 17.11.23

Kim Johnston

From: Sonia Quirion
Sent: Tuesday, July 10, 2018 7:53 AM
To: Kim Johnston; Michelle GagnonDonovan
Cc: Shipping
Subject: L/B

647.5701 s090283 s090282 s090280 s090279

D350-721-045 S090198 X1

D412-698-041 S090184 X1

D412-698-042 S090167 X1

D350-591-121 S073663 RED AND WHITE

P/W

DSI 9783-011 X1

D205-523-013 X1

Change Record

PAGE 1 OF 1

Part Number: D412-698-041/-042

Description: HINGE PANEL AUTOMATIC DOOR OPENER LH/RH (STANDARD)

[illegible]